



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

650.6210

Job Sheet 210872



Part No: 650.6210

Part Name: BANJO -4



Part Weight: 0 lbs

Job Created: 6/24/20

Due Date: 7/9/20

Type: SOLD

Note: 650.6200 REV.PE1 IPP REV:A 20.06.10 NEW ISSUE DD VERF:JFS

Ship Via:

Job Qty: 3 pcs

Status: New

Priority: Medium

Job Tracking No:

Created By: Jennifer Renwick

Description:

Aw 139 Valve

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	SL-154 - 1	3 pcs	7/2/20		1.00	0.75	Doosan - 1		JB 20.07.13
							NLX 2500SY - 1		
							SL-154 - 1		
							SL-2500Y - 1		
110	QC 2	3 pcs	7/2/20		0.00	0.00	QC 2 - 1		JB 20.07.13
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



Container No: S287547



Part: 650.6210

Job No: 210872

Serial No/Batch: S287547

Revision: REV.PE1

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/13/20

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SUIWA

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				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
120	QC 8	3 pcs	7/2/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
					QC 8 - 73
					QC 8 - 82
130	Outsource - 17 - Passivate	3 pcs	7/9/20		GRO002-VC 5
140	Packaging 2-1 - Receive - B4B	3 pcs	7/9/20	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B

m/20/07/20

H/2020-07-27

JUL 30 2020

				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 37 - B4B	
150 QC 6	3 pcs	7/9/20	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
				QC 6 - 82	
					DAS 82 9-89 AUG 28 2020
160 Packaging 3-1 - Stock - B4B	3 pcs	7/9/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 37 - B4B	
					DAS 82 9-89 AUG 28 2020
170 QC 21 - SA	3 pcs	7/9/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 9	
Part Op 100 - 1-Machine as per folio F FOLIO REV: <u>AA</u> DWG REV: <u>PE1</u> 2-Debur Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 120 - QC8- Inspect parts - second check 130 - -Issue P/O; <u>46796</u> PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 17-4PH H1150 stainless steel - Certificate of Conformity is required 140 - Certificate of Conformity is required 150 - QC6- All purchased or subcontracted products 160 - Identify as per dwg & Stock 170 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M17-4-H1150-R1.000	17-4 SS Round Bar 1.000"	.4200 ft (.14 ea)	100-SL-154 - 1	M126689	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-SL-154 - 1	M17-4-H1150-R1.000	0	2	0
Part Specifications				
Specifications could not be found.				

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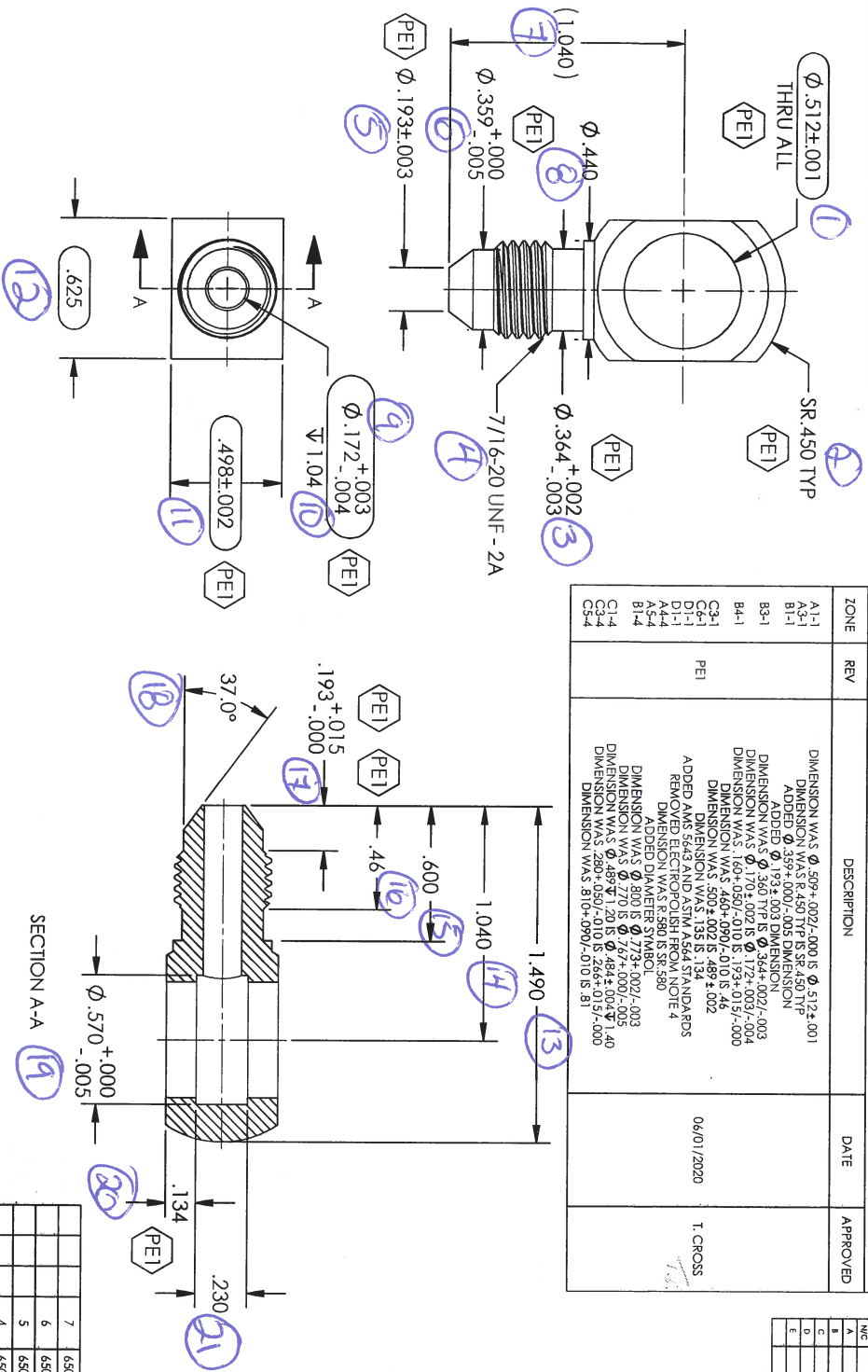
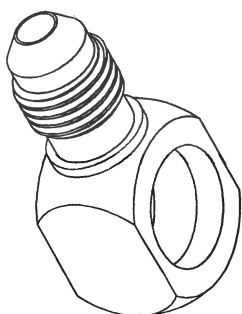
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PROTOTYPE REVISIONS

ZONE	REV	DESCRIPTION	DATE	APPROVED
A1-1		DIMENSION WAS $\phi .599 \pm .002$ IS $\phi .512 \pm .001$		
A3-1		DIMENSION WAS $\phi .450$ TYP IS SR 450 TYP		
B1-1		ADDED $\phi .359 \pm .005$ DIMENSION		
B3-1		ADDED $\phi .193 \pm .003$ DIMENSION		
B4-1		DIMENSION WAS $\phi .170 \pm .002$ IS $\phi .364 \pm .002$ - .003		
C3-1		DIMENSION WAS $\phi .0250 \pm .010$ IS $\phi .173 \pm .015$ - .005		
D1-1		DIMENSION WAS $\phi .489 \pm .002$ IS $\phi .489 \pm .002$		
D1-1		DIMENSION WAS $\phi .500 \pm .002$ IS $\phi .134 \pm .002$		
A5-4		ADDED AMS 5643 AND ASTM A564 STANDARDS		
A5-4		REMOVED ELECTROPOLISH FROM NOTE 4		
B1-4		DIMENSION WAS $\phi .580$ IS $\phi .580$		
C1-4		DIMENSION WAS $\phi .800$ IS $\phi .773 \pm .002$ - .003		
C3-4		DIMENSION WAS $\phi .770$ IS $\phi .767 \pm .000$ - .005		
C3-4		DIMENSION WAS $\phi .484 \pm .004$ IS $\phi .484 \pm .004$		
C3-4		DIMENSION WAS $\phi .280 \pm .050$ - .010 IS $\phi .266 \pm .015$ - .000		
C3-4		DIMENSION WAS $\phi .810 \pm .090$ - .010 IS .81		

REV	DESCRIPTION	DATE	APPROVED
A	INITIAL RELEASE	04-30-14	P. BRAVO
B	INCORPORATED ECU 0443	06-16-2014	P. BRAVO
C	INCORPORATED ECU 0500	06-16-2015	P. BRAVO
D	INCORPORATED ECU 0647	06-16-2015	P. BRAVO
E	INCORPORATED ECU 0610	10-25-2016	P. BRAVO
F	INCORPORATED ECU 0610	11-06-2016	P. BRAVO

650.6210



NOTES:

1. DEBURR AND BREAK ALL SHARP EDGES.
2. MATERIAL: 17-4PH H1150 STAINLESS STEEL IAW AMS 5643 OR ASTM A564
3. IDENTIFY IAW MPP-120.
4. FINISH: IAW MPP-172 PASSIVATE IAW SECTION 6.1

QTY	PART #	DESCRIPTION	MATL	SPEC.
7	650.6216	BANJO-4 FLARELESS	△	△
6	650.6215	DUAL BANJO-8-10	△	△
5	650.6214	DUAL BANJO-8	△	△
4	650.6213	BANJO-10	△	△
3	650.6212	BANJO-8	△	△
2	650.6211	BANJO-6	△	△
1	650.6210	BANJO-4	△	△

ORIGINAL DATE	04-30-14	DATE	04-30-14
DESIGNED BY	N. CAV	DESIGNED BY	N. CAV
DESIGNED BY	P. BRAVO	DESIGNED BY	P. BRAVO
DESIGNED BY	P. BRAVO	DESIGNED BY	P. BRAVO
DESIGNED BY	P. BRAVO	DESIGNED BY	P. BRAVO
DESIGNED BY	P. BRAVO	DESIGNED BY	P. BRAVO
DESIGNED BY	P. BRAVO	DESIGNED BY	P. BRAVO
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SCALE	1:1	SCALE	1:1

210872
work order#



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046796



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046796

PO Date: 7/27/20

Due Date: 8/4/20

**Purchase Order
Revision:**

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2020-07-28

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	211477	650.6511	650.6500 REV.PB2	Fill Port Adapter -Issue P/O; PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 303 stainless steel -Certificate of Conformity is required	Firmed x5	-	8/4/20	5 pcs	0 pcs	5 pcs	\$4.7619/pcs	\$23.81
2	210873	650.6213	650.6200 REV.PE1	Banjo -10 -Issue P/O; PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 17-4PH H1150 stainless steel -Certificate of Conformity is required	Firmed x2	-	8/4/20	2 pcs	0 pcs	2 pcs	\$4.7619/pcs	\$9.52



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PURCHASE ORDER

POHB046796



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	210872	650.6210	650.6200 REV.PE1	BANJO -4 -Issue P/O; PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 17-4PH H1150 stainless steel -Certificate of Conformity is required	Firmed X3	-	8/4/20	3 pcs	0 pcs	3 pcs	\$4.7619/pcs	\$14.29
4	211168	650.6312	650.6300 REV.PG2	Screen Retainer -Issue P/O; PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 17-4PH H900 stainless steel - Certificate of Conformity is required	Firmed X3	-	8/4/20	3 pcs	0 pcs	3 pcs	\$4.7619/pcs	\$14.29
5	210647	650.7711	650.7700 REV.PF1	Cap Retainer -Issue P/O; PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 303 stainless steel -Certificate of Conformity is required	Firmed X3	-	8/4/20	3 pcs	0 pcs	3 pcs	\$4.7619/pcs	\$14.29



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K6A 1K7
Canada

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PURCHASE ORDER

POHB046796



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	210875	650.6316	650.6300 REV.PG2	Swivel Fitting -Issue P/O; PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 17-4PH H900 stainless steel - Certificate of Conformity is required	Firmed x2	-	8/4/20	2 pcs	0 pcs	2 pcs	\$4.7619/pcs	\$9.52
7	211167	650.6310	650.6300 REV.PG2	Swivel Fitting -Issue P/O; PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 17-4PH H900 stainless steel - Certificate of Conformity is required	Firmed x3	-	8/4/20	3 pcs	0 pcs	3 pcs	\$4.7619/pcs	\$14.29
Grand Total:												\$100.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Khuerin

Plex 7/28/20 1:48 PM Dart.Guerin.Kimberley


Certificat de Conformité / Certificate of Compliance


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2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupealtech.com

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Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
28-Jul-2020		Ian Wilson		POHB046796					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
1	650.6511 Rev.PB2	650.6511 01 - PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] TEST ONE PART FIRST REF-PASSIVATION ASTM A380-PASSIVATION AMS 2700/QQ-P-35, PASSIVATION ASTM A967. Precleaning with rags and solvent if required remove any markings, paintor and heavy contaminants. 02 - Dégraissage Acier tout alliage 03 - Décapage et désoxydation des aciers inoxydables selon ASTM A967 et A380 04 - Passivation des aciers inoxydables selon ASTM A967-13, ASTM-A380-13 05 - Emballage et identification des pièces	PASSIVATION CH	5	5	0	0	0	
2	650.6213 Rev.PE1	650.6213 01 - PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] TEST ONE PART FIRST REF-PASSIVATION ASTM A380-PASSIVATION AMS 2700/QQ-P-35, PASSIVATION ASTM A967. Precleaning with rags and solvent if required remove any markings, paintor and heavy contaminants. 02 - Dégraissage Acier tout alliage 03 - Décapage et désoxydation des aciers inoxydables selon ASTM A967 et A380 04 - Passivation des aciers inoxydables selon ASTM A967-13, ASTM-A380-13 05 - Emballage et identification des pièces	PASSIVATION CH	2	2	0	0	0	
3	650.6210 Rev.PE1	650.6210 01 - PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] TEST ONE PART FIRST REF-PASSIVATION ASTM A380-PASSIVATION AMS 2700/QQ-P-35, PASSIVATION ASTM A967. Precleaning with rags and solvent if required remove any markings, paintor and heavy contaminants. 02 - Dégraissage Acier tout alliage 03 - Décapage et désoxydation des aciers inoxydables selon ASTM A967 et A380 04 - Passivation des aciers inoxydables selon ASTM A967-13, ASTM-A380-13 05 - Emballage et identification des pièces	PASSIVATION CH	3	3	0	0	0	

 DAS
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9-89

RECEIVED

JUL 29 2020

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 www.groupaltech.com

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Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax:.

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
28-Jul-2020		Ian Wilson		POHB046796				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
4	650.6312 Rev.PG2	650.6312 01 - PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] TEST ONE PART FIRST REF:-PASSIVATION ASTM A380-PASSIVATION AMS 2700/QQ-P-35, PASSIVATION ASTM A967. Precleaning with rags and solvant if required remove any markings, paintor and heavy contaminants. 02 - Dégraissage Acier tout alliage 03 - Décapage et désoxydation des aciers inoxydables selon ASTM A967 et A380 04 - Passivation des aciers inoxydables selon ASTM A967-13, ASTM-A380-13 05 - Emballage et identification des pièces	PASSIVATION CH	3	3	0	0	0
5	650.7711 Rev.PF1	650.7711 01 - PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] TEST ONE PART FIRST REF:-PASSIVATION ASTM A380-PASSIVATION AMS 2700/QQ-P-35, PASSIVATION ASTM A967. Precleaning with rags and solvant if required remove any markings, paintor and heavy contaminants. 02 - Dégraissage Acier tout alliage 03 - Décapage et désoxydation des aciers inoxydables selon ASTM A967 et A380 04 - Passivation des aciers inoxydables selon ASTM A967-13, ASTM-A380-13 05 - Emballage et identification des pièces	PASSIVATION CH	3	3	0	0	0
6	650.6316 Rev.PG2	650.6316 01 - PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] TEST ONE PART FIRST REF:-PASSIVATION ASTM A380-PASSIVATION AMS 2700/QQ-P-35, PASSIVATION ASTM A967. Precleaning with rags and solvant if required remove any markings, paintor and heavy contaminants. 02 - Dégraissage Acier tout alliage 03 - Décapage et désoxydation des aciers inoxydables selon ASTM A967 et A380 04 - Passivation des aciers inoxydables selon ASTM A967-13, ASTM-A380-13 05 - Emballage et identification des pièces	PASSIVATION CH	2	2	0	0	0


Certificat de Conformité / Certificate of Compliance


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Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
28-Jul-2020		Ian Wilson		POHB046796					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Quantités / Quantities					
				Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
7	650.6310 Rev.PG2	650.6310 01 - PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] TEST ONE PART FIRST REF:-PASSIVATION ASTM A380-PASSIVATION AMS 2700/QQ-P-35, PASSIVATION ASTM A967. Precleaning with rags and solvent if required remove any markings, paintor and heavy contaminants. 02 - Dégraissage Acier tout alliage 03 - Décapage et désoxydation des aciers inoxydables selon ASTM A967 et A380 04 - Passivation des aciers inoxydables selon ASTM A967-13, ASTM-A380-13 05 - Emballage et identification des pièces	PASSIVATION CH	3	3	0	0	0	

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 JUL 29 2020
 DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes**Epaisseur réelle
Actual Thickness**
**Inspecteur Qualité
Quality Inspector**
**Réçu par
Received By**

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.



Castle Metals®

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 1 of 1

Shipment No:1859559

Ship From:	Sold To:			Ship To:	Deliver To:
A. M. Castle & Co. MONTREAL - CASTLE METALS 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2	DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA			DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN	DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA
Date Shipped	F.O.B.	Freight Terms	Carrier	BOL No	
22-AUG-2013	ORIGIN	Prepaid	MANITOULIN	1859559-2	

Shipment Details		Final Destination Branch - MON
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Order No	Line No	Item No	Description				
2995892	2	23970	1.0000.RD.17CR-4NI.STAINLESS.CF.H1150.132.0000-156.0000 SPECIFICATIONS: AMS 5643 Email P/s and Certs to : clavoie@dartaero.com				
Purchase Order No	Part Number		Ordered Qty		Invoice Qty		
20939			12.00 FT		11.5000 FT		
Details			ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #S FORWARD COPY OF P/S TO TRACY (MONTREAL) Email P/s and certs to: clavoie@dartaero.com END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS ECCN # EAR99				
Delivery No.	Mill	Heat Number	Mech Id	PCS	Width (IN)	Length (IN)	Shipped Qty(LBS)
119063912	OUTOKUMPU STAINLESS INC.	G18959		1		138.0000	30.7050

SP 13-8-23

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 90 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned.

Authorized Castle Metals Representative:

Date: Name:

OUTOKUMPU

HEAT G18959

Certificate of Test

ORDER 627435/ 04 BOL 0217841 * CERTIFICATION * 06/21/12

SHIP TO:

A. M. CASTLE METALS
3400 NORTH WOLF ROAD

FRANKLIN PARK

601310000

147459

YOUR ORDER & DATE
6/21/12 CUST# 0254001 CUST TAG#23970

ITEM DESCRIPTION

GRADE 17-4 Ship Condition H1150
Size 17-4 RND CFA H1150 x 1.0000 x 144.000 RL
Country of Melt: UNITED STATES Country of Mfg.: UNITED STATES
NAFTA Country of Origin is Country of Melt

No weld repair
Free of mercury contamination, Free of radiation contamination
No WEEE relevant substances; Meets EU electrical ROHS

Total Bundles 1 Total Weight 3018

WO 2031141 Bundles: 1C

SPECIFICATIONS

THE PRODUCTS LISTED ON THIS MILL TEST REPORT SATISFY PREFERENCE CRITERION B
AS DEFINED IN ARTICLE 401 OF THE NORTH AMERICAN FREE TRADE AGREEMENT.

AMS 2303F
ASME SA564 E10 A11a
ASTM A564 10 Type 630
AM Castle 3174-04 R31
Aged at 1150F for 4 hr, AC

UNS S17400, AISI 630
ASTM A484 11
DFARS 252.225.7009 10/4/11
Sol Ann 1900F/1Hr/Rapid Cool
AMS 5643R Chemistry

MECHANICAL & OTHER TESTS

Hardness as shipped	327 HB		
Hardness as shipped	035 HRC		
Grain size	6.0	Tensile strength, KSI (MPa)	150.0 (1034)
Micro	OK	0.2% Yield Strength, KSI (MPa)	132.0 (910)
Intergranular corrosion			
Macro	OK	Elongation % in 4D	18.0
		Reduction of area %	59.0
		Charpy (ft lb)	92 100 104 Avg 98
		Charpy Test Temperature	RT
Ferrite	1.0	Lateral Exp (mils)	43 50 52 Avg 48

CHEMICAL COMPOSITION

Carbon (C)	.026	Manganese (Mn)	.810
Phosphorus (P)	.020	Sulphur (S)	.028
Silicon (Si)	.430	Chromium (Cr)	15.390
Nickel (Ni)	4.280	Cobalt (Co)	.050
Copper (Cu)	3.800	Moly (Mo)	.260
Nitrogen (N)	.034	Columbium (Cb)	.250
Titanium (Ti)	.010	Aluminum (Al)	.010
Tin (Sn)	.010	Boron (B)	.001
Tantalum (Ta)	.010	Vanadium (V)	.070
Tungsten (W)	.050		.000
Columbium/			
Tantalum (Cb+Ta)	.260		
Iron (Fe)	Balance	Severity	.000
Frequency	.000		
Melt Practice	EAF		
Refining Practice	AOD		
De-long Ferrite			

Knowingly & willfully falsifying or concealing a material act on this form,
or making false, fictitious or fraudulent statements or representations
herein could constitute a felony punishable under federal statutes.
We hereby certify that the test results shown in this report are correct and
accurate as contained in the records of the company and are in compliance
with the specifications, codes, and standards listed above.

M.F. Marcanio, Quality Manager

M.F. Marcanio

